

Work Order ID 60770

July 22, 2010 11:03:16 AM

Page 1

Item ID: D2986-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Rubber Spacer

Start Date: 7/22/10 Start Qty: 7.00

Cust Item ID:

Required Date: 7/27/10 Req'd Qty: 7.00

Customer:

Reference:

Run Start

Approvals: Process Plan: CY Date: 10/7/22 Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2986	Rev B
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0.00

100
Waterjet

FLOW WATER JET

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D2986

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

B10-7-22

9

110
QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

template DT3187-1T1

0.00

B10-7-22

120
QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/22

29

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: 242

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-7-22 (925)

10/07/23

MF
10-7-23

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60770



Parent Item: D2986-1

Parent Item Name: Rubber Spacer

Start Date: 7/22/10

Start Qty: 7.00

Required Date: 7/27/10

Required Qty: 7.00

Comments: IPP Rev:B 09-01-20 rev.B as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4111NS.125

Purchased

No

100

sf

851.4000

5.466

40.27579

65.5



4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

B10-7-22

Location

Loc Qty

Loc Code

MAT

500

114937

500

MAT052

351.4

112335

351.4

112335

9

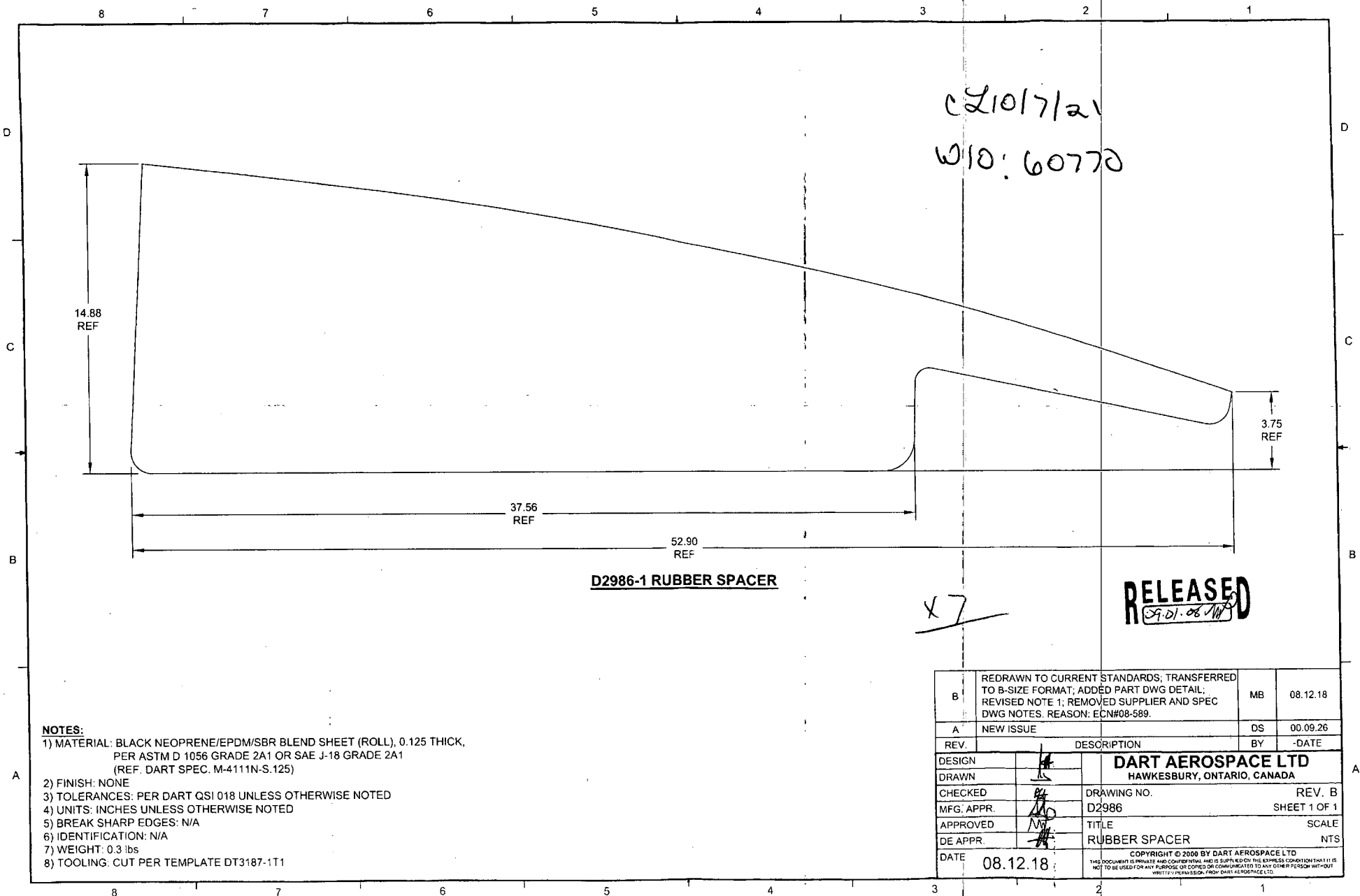
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
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				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET (ROLL), 0.125 THICK,
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
(REF. DART SPEC. M-4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: CUT PER TEMPLATE DT3187-1T1

B	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED PART DWG DETAIL; REVISED NOTE 1; REMOVED SUPPLIER AND SPEC DWG NOTES. REASON: ECN#08-589.		MB	08.12.18
A	NEW ISSUE		DS	00.09.26
REV.	DESCRIPTION		BY	-DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO. REV. B	
APPROVED	DE APPR.		D2986 SHEET 1 OF 1	
DATE	08.12.18		TITLE SCALE	
		RUBBER SPACER		NTS
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